

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014416**Date Inspected:** 22-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Bay 12, Deck Panel 13AW-DP3117-001

QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13AW-DP3117-001, 2 ribs, 3 welds, 75 total tack welds inspected.

Weld 1 scanned 25 locations with 3 indications.

Weld 2 scanned 25 locations with 7 indications.

Weld 3 scanned 25 locations with 1 indication.

Bay 9, OBG Lift 13, U-Rib Internal Cover Plate

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously tested and accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. This QA inspector generated UT report for

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this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

DP3080-001-191, 192, 193, 194, 195, 196, 197, 198, 211, 212, 213, 214, 215, 216, 217, 218

This Quality Assurance (QA) Inspector observed the following work in progress:

This inspector performed In- Process inspections of production welding of deck panels in Bay 9. Welding was being performed on panel DP3075-001. The weld procedure was found to be WPS-B-T-2342-U1-(U-rib)-5. The welding operators were identified as follows:

Weld 1- 203805
Weld 2- 059378
Weld 5- 059418
Weld 6- 059421
Weld 9- 059416
Weld 10- 201788

ZPMC and ABF QC were present during the welding process and identified as Chen Shi Gang and Huang Wen Guang respectively. The ZPMC CWI was present during the welding process and identified as Guo Yanfei.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
